

Date: Wednesday, 6/28/2006 4:10:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ADJUSTABLE ENGINE MOUNT KIT (205)
 Job Number : 27723
 Estimate Number : 10548
 P.O. Number : N/A Part Number : D205708011
 This Issue : 6/28/2006 S.O. No. : N/A Drawing Number : B80701 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C
 Previous Run : 24761 Material : N/A
 Written By : *See Comment Below* Due Date : 7/22/2006 Qty: 4 Um: Each
 Checked & Approved By : *KS 06 06 29 N*
 Comment : Est C 06.01.31 Added MS206136C12 JLM/AP

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

Rel attached 12

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____ for:

6	D3284-001	Sleeve
2	D3284-003	Stud
4	D3284-005	Stud
6	D3284-007	Stud
6	NAS509-12	Nut
6	NAS509L12	NutStud

P/O: 1581 c Loc 129/04

To be assembled as per Dwg B80701 Rev. C

Possible Supplier: Northern Aero

Certificate of Conformity is required

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure Certificate of Conformity is attached

KS 06 07 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 27723

Part Number: D205708011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect assembly. Visually inspect thread, fit and cad plating

5.0

D3284001

Sleeve



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

6	D3284-001	Sleeve	B27723
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6.0

D3284003

Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Stud

Pick:

Packing Kit (Note: (1) D205-708-011 Kit includes all parts listed below)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D3284-003	Stud	B27723
---	-----------	------	--------

7.0

D3284005

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	D3284-005	Stud	B27723
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8.0

D3284007

Stud



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

6	D3284-007	Stud	B27723
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 27723

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D3284009

Bearing



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bearing

Pick:

Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	D3284-009	Bearing	B24775 8mcy

B27843 16mcy

10.0

D3284011

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bearing

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty	Part Number	Description	Batch
1	D3284-011	Bearing	B24776-2 2mcy

B27752 2mcy

11.0

MS206136C16

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty	Part Number	Description	Batch
8	MS20613-6C16Rivet		M19098 8mcy

M19392 22

M19349 2mcy

MS20613-6C18 - cut to size 16

12.0

MS206136C18

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
8	MS20613-6C18 Rivet		M18438 14mcy

M19349 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 27723

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS206136C19

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D205-708-011

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
8	MS20613-6C19	Rivet	M19349 ✓

-20's - cut to size -19

u

14.0

NAS50912

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509-12	Nut	B27723

15.0

NAS509L12

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509L12	Nut	B27723

16.0

MS206136C12

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
2	MS206136C12	Rivet	M100089 ✓

P04/2/7 (4)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS




Comment: INSPECT 100% KITS FOR COMPLETENESS

28 06/07/13 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:10:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 27723

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-708-011

Location:

PPP Rev: A

DOCUMENT CONTROL

19.0

DC



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.14

Job Completion



4 06.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

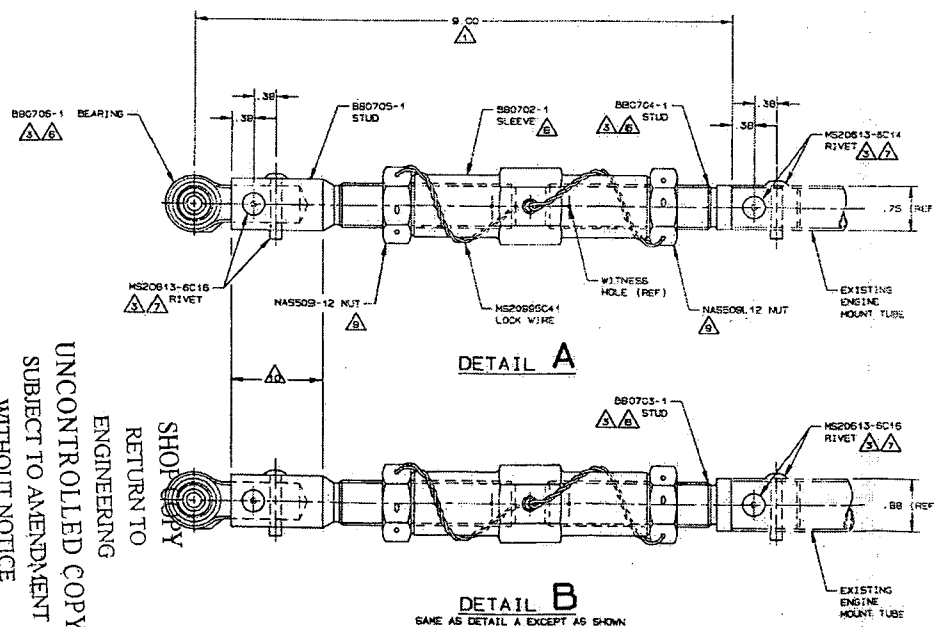
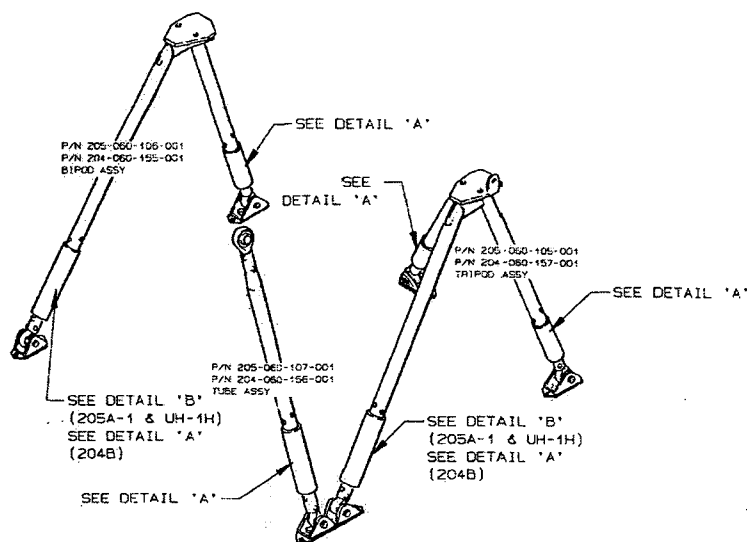
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

- 1 CUT EXISTING ENGINE MOUNT TUBE AT DIMENSION SHOWN.
- 2 DEBURR OUTSIDE DIAMETER OF TUBE .005/.010 AND CHAMFER INSIDE DIAMETER .015/.025.
- 3 BOTTOM OUT BEARING IN B60705 STUD AND B60703/B60704 STUD IN TUBE. POSITION RIVET HOLES AS SHOWN AND LINE RIVET PARTS. (64 DIA [1/16] DRILL).
- 4 DISASSEMBLE PARTS AND DEBURR.
- 5 ZINC CHROMATE PRIME TUBE ASSY ALL OVER USING TT-P-1757, COLOUR GREEN.
- 6 RE-ASSEMBLE PARTS WET WITH HYSOL ADHESIVE EA834.
- 7 INSTALL RIVETS WET WITH HYSOL ADHESIVE EA834.
- 8 FILL SLEEVE WITH CORROSION PREVENTIVE COMPOUND MIL-C-16473 SUFFICIENT TO CAUSE SQUEEZE OUT. THEN ASSEMBLE THREADED PARTS AS SHOWN.
- 9 FOR AIRCRAFT INSTALLATION, BACK OFF NUTS AND ORIENT BEARINGS TO SUIT ENGINE DECK FITTINGS. ADJUST LENGTHS OF INDIVIDUAL TUBES WITH SLEEVE TO OBTAIN CORRECT ENGINE/TRANSMISSION ALIGNMENT PER BULB INTERFERENCE MANUAL. MAKE SURE STUDS ARE STILL VISIBLE THROUGH WITNESS HOLES. TORQUE NUTS 400 TO 800 IN-LBS AND LOCKWIRE AS SHOWN. SEAL LOCKWIRE HOLES IN SLEEVE AND AROUND NUT/THREAD INTERFACE WITH SEALANT PER MIL-S-8802.
- 10 ZINC CHROMATE WHERE INDICATED USING TT-P-1757, COLOUR GREEN.



SHOPY COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27723

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REV.	Date	Description of changes	by	approved
N/C	06 JAN 98	INITIAL RELEASE	TM	TM MARTIN
A	18 MAY 99	REV. MAT. LIST, ADD B60706-1 BRG.	GW	TM MARTIN
B	01 FEB 00	DOH B60701A1 INCORPORATED	TM	TM MARTIN
C	09 OCT 03	DOH B60701A1 INCPD	TM	TM <i>Mart</i>

RELEASED 1975
OCT 14 2003
SPRO CONSULTING SERVICES LTD

AR	AR	EA934	ADHESIVE	DEXTERA-TYROL
6	6	B80706-1	BEARING	ACS
AR	AR		SEALANT	MIL-S-9802, CLASS B
AR	AR		CORROSION PREVENTIVE COMPOUND	MIL-C-16173, GRADE 1
AR	AR	MS20995C41	LOCK WIRE	
12	6	MS20613-6C14	RIVET	
12	16	MS20613-6C16	RIVET	
6	6	NAS506L12	NUT	
6	6	NAS506-12	NUT	
6	6	B80705-1	STUD	
6	4	B80704-1	STUD	
	2	B80703-1	STUD	
6	6	B80702-1	SLEEVE	
1	1	-3	INSTALLATION	
1	1	-1	INSTALLATION	
-3	-1	PART NO.	DESCRIPTION	MATERIAL

LIST OF MATERIALS			
DRAWN: T MARTIN CHECKED: PROJECT ENGINEER SYSTECS: AVIONICS:	DATE	NORTHEN AERO INDUSTRIES 1845 ST. MATTHEWS AVENUE WINNIPEG, MANITOBA R4S 4A6	
	27 JAN 68	INSTALLATION - ENGINE MOUNT, ADJUSTABLE, BELL 204/205	
		CODE IDENT NO.	DWG. NO.
		36929	B80701 C
		SHEET FULL	SHEET 1 OF 1

APPC CONSULTING SERVICES COMPLETE DRAFTING SYSTEM

1. Approving national aviation authority / country TRANSPORT CANADA		2. AUTHORIZED RELEASE CERTIFICATE TCCA 24-0078			3. Form tracking No. SO14078-1	
4. Approved organization name and address AMO 88-97		4. NORTHERN AERO INDUSTRIES LTD. 1845 St. Matthews Avenue Winnipeg, Manitoba R3H 0A8 Canada			5. Work Order/Contract/Invoice P 00001581	

6. Item	7. Description	8. Part No.	9. Eligibility*	10. Qty.	11. Serial/Batch No.	12. Status/Work
1	NUT	NAS509-12 -	various	24	BATCH # 05-2618	Manufactured
2	NUT	NAS509-L12 -	various	24	BATCH # 05-2618	Manufactured
3	SLEEVE	B80702-1	BELL 205A-1 205B 204B	24	BATCH # 06-1013	Manufactured
4	7/8 STUD	B80703-1	UH-1H BELL 205A-1 205B UH-1H	8	BATCH # 05-2276	Manufactured

13. Remarks
Items 1 & 2: These Aeronautical Products were procured from a approved source in accordance with Northern Aero Industries Ltd. Qualified Procurement List.

Items 3 & 4: These Aeronautical Products conform to approved data in accordance with TCCA STC Number SH99-11 and ((FAA STC Number SR00953NY and SR01395NY)).

14. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 13.		19. <input type="checkbox"/> CAR 571.10 Maintenance Release <input checked="" type="checkbox"/> Other regulations specified in block 13 Certifies that, except where otherwise specified in block 13 the work identified in block 12, and described in block 13 was performed in accordance with CAR 571.	
15. Authorized Signature 17. Name R. D. Williamson	16. Certificate / Approval Ref. No. AMO 88-97 18. Date (DD MMM YYYY) 05 July 2006	20. Authorized Signature N/A 22. Name N/A	21. Certificate / Approval Ref. No. N/A 23. Date (DD MMM YYYY)

INSTALLER RESPONSIBILITIES

*Installer must cross-check eligibility with approved data.

This document does not constitute authority to install the part.

Where the installer works in accordance with the national regulations of an airworthiness authority other than the authority specified in block 1, the installer must ensure that his/her airworthiness authority accepts products or maintenance from the airworthiness authority specified in block 1.

Statements 14 and 19 do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification, issued in accordance with the national regulations of the state of registry, before the aircraft may be flown.

Approving national aviation authority / country TRANSPORT CANADA		AUTHORIZED RELEASE CERTIFICATE TCCA 24-0078				3. Form tracking No. S014078-2	
4. Approved organization name and address AMO 88-97		NORTHERN AERO INDUSTRIES LTD. 1845 St. Matthews Avenue Winnipeg, Manitoba R3H 0A8 Canada				5. Work Order/Contract/Invoice P.O 00001581	

6. Item	7. Description	8. Part No.	9. Eligibility*	10. Qty.	11. Serial/Batch No.	12. Status/Work
5	3/4 STUD	B80704-1	BELL 205A-1 205B 204B	16	BATCH # 06-1011	Manufactured
6	STUD	B80705-1	UH-1H BELL 205A-1 205B 204B UH-1H	24	BATCH # 06-1001	Manufactured

13. Remarks
 These Aeronautical Products conform to approved data in accordance with TCCA STC Number SH99-11 and (FAA STC Number SR00953NY and SR01395NY).

14. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 13.

☐ CAR 571.10
 Maintenance Release
☐ Other regulations specified in block 13

Certifies that, except where otherwise specified in block 13, the work identified in block 12 and described in block 13 was performed in accordance with CAR 571.

15. Authorized Signature 	16. Certificate / Approval Ref. No. AMO 88-97	20. Authorized Signature N/A	21. Certificate / Approval Ref. No. N/A
17. Name R. D. Williamson	18. Date (DD MMM YYYY) 05 July 2006	22. Name N/A	23. Date (DD MMM YYYY)

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